

Work Order ID 86585

86585

Page 1

July-05-12 1:14:25 PM

Item ID: D2989-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Lid Assembly

Stop

NS2

Start Date: 7/05/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CD

Date: 12/07/05 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: M122130

1x

PL 12-12-17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

DA
23
89
12-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Lid Assembly

Stop

NS2

Start Date: 7/05/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

DAS

DAS

0.00

15

09

12/18

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Hand Finishing

Memo

0.00

1 12/18 12-12-18

W/O:		WORK ORDER CHANGES					
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July-05-12 1:14:25 PM

Item ID:	D2989-043	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Basket Lid Assembly						
Start Date:	7/05/12	Start Qty:	1.00	*1*	Cust Item ID:		
Required Date:	8/03/12	Req'd Qty:	1.00	*1*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							<i>MK</i>
	Memo	0.00							<i>1X</i>
	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								<i>12/12/18</i>
	1ST COAT	<i>1:00</i>							
	START TIME:	<i>4:00</i>							
	OVEN TEMPERATURE:								
	FINISH TIME:								
	***** 2nd coat if necessary *****								
	2ND COAT:	<i>2:00</i>							
	START TIME:	<i>4:00</i>							
	OVEN TEMPERATURE:								
	FINISH TIME:	<i>2:30</i>							
140 *140* QC	QC3- Inspect Part Finish	0.00							<i>1 φ 12-12-19 250</i>
	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July-05-12 1:14:25 PM

Item ID:	D2989-043	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:						Stop	*NS2*	
Item Name:	Basket Lid Assembly							
Start Date:	7/05/12	Start Qty:	1.00	*1*	Cust Item ID:			
Required Date:	8/03/12	Req'd Qty:	1.00	*1*	Customer:			
Reference:						Run	Start	*NR1*
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop	*NR2*	
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>D350-604-043</i>	<i>0.00</i>	<i>87538</i>			<i>1</i>	<i>0</i>	<i>61212-19</i>	
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							<i>13/19/18</i>
	Memo								
	Memo	0.00							

*MF
12-12-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86585

Parent Item: D2989-043

Start Date: 7/05/12

Required Date: 8/03/12

Parent Item Name: Basket Lid Assembly

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	1	1	24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			8						
					83907		8						
D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1	24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			4						
					77527		4						
				WA005			1						
					72408		1						
D2989-4 Rib		Manufactured	No			100	Each	5.0000	1	1	24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA005			5						
					72409		1						
					77524		4						
D2989-5 Rib		Manufactured	No			100	Each	4.0000	2		24 8-89	12-12-12	
				<u>Location</u>			<u>Loc Qty</u>						
				WA			3						
					81911		3						
				WA005			1						
					71222		1						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 86585

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3182-1

Hinge

Manufactured No 100 Each 12.0000 2

2 24 12.12.12
DAS

Location Loc Qty Loc Code

WA 12
77316 4
82707 8

D3442-3

Shim

Manufactured No 100 Each 14.0000 2

2 24 12.12.12
DAS

Location Loc Qty Loc Code

WA 14
79123 6
82708 8

D3829-041

Rib Assembly (Inboard)

Manufactured No 100 Each 11.0000 1

1 24 12.12.12
DAS

Location Loc Qty Loc Code

WA 5
81038 5
WA006 6
72729 1
84792 5

D3832-5

Mesh (Lid)

D3833-5

Mesh (Lid End)

Manufactured No 100 Each 0.0000

B77756 → ① 12.12.12
DAS

Manufactured No 100 Each 38.0000

B6746.1 ② 12.12.12
DAS

Location Loc Qty Loc Code

WA035 38
67461 38

D3838-041

Rib Assembly (Basket Lid, LH)

Manufactured No 100 Each 5.0000 1

1 24 12.12.12
DAS

Location Loc Qty Loc Code

WA005 5
77525 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 86585

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3838-042

Rib Assembly (Basket Lid, RH)

Manufactured No

100 Each 5.0000

1

1

24
12-12-12

EB 84-798

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA005	5	
72415	1	
77526	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/04

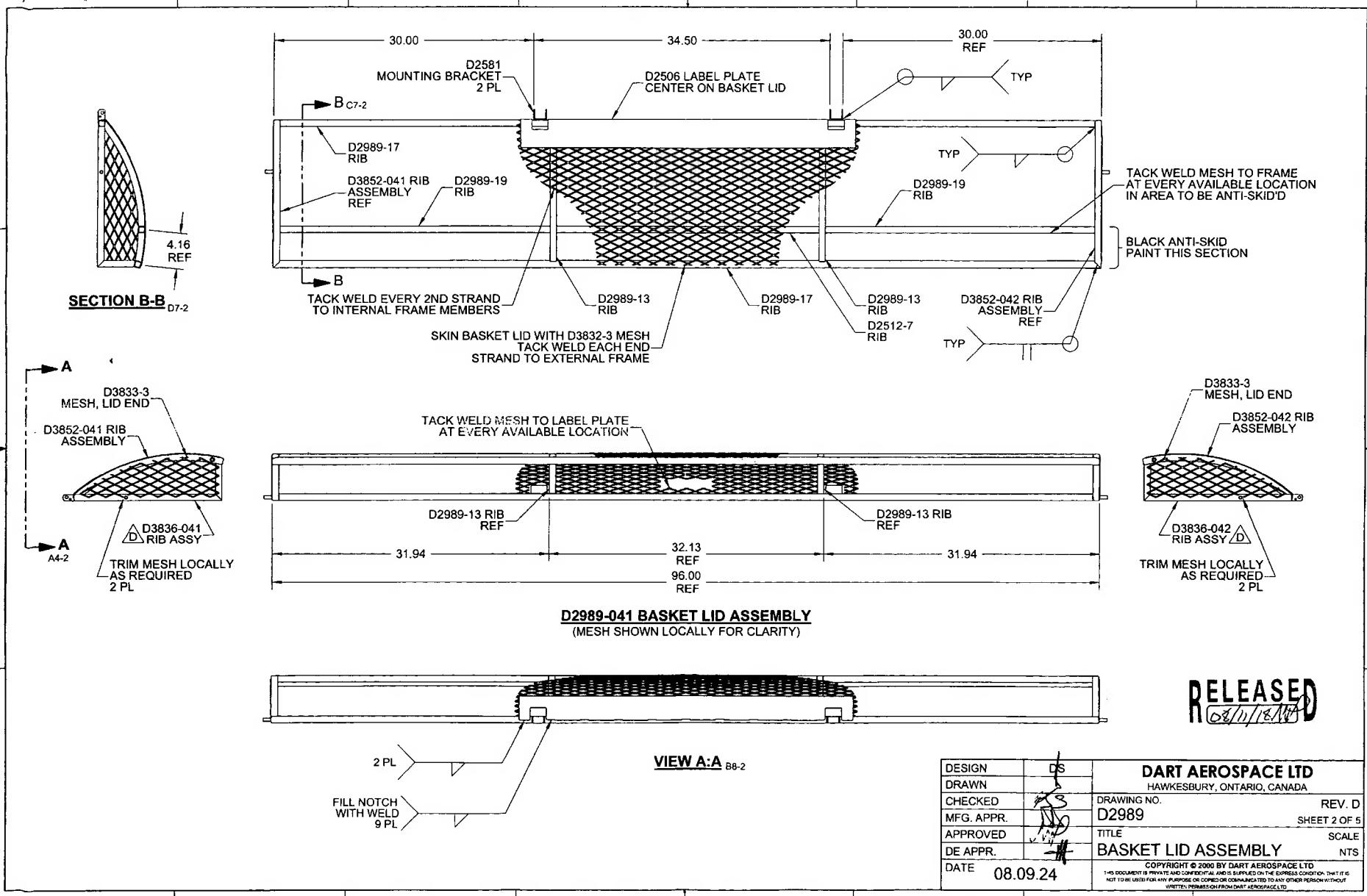
C812107105
WTO: 86585

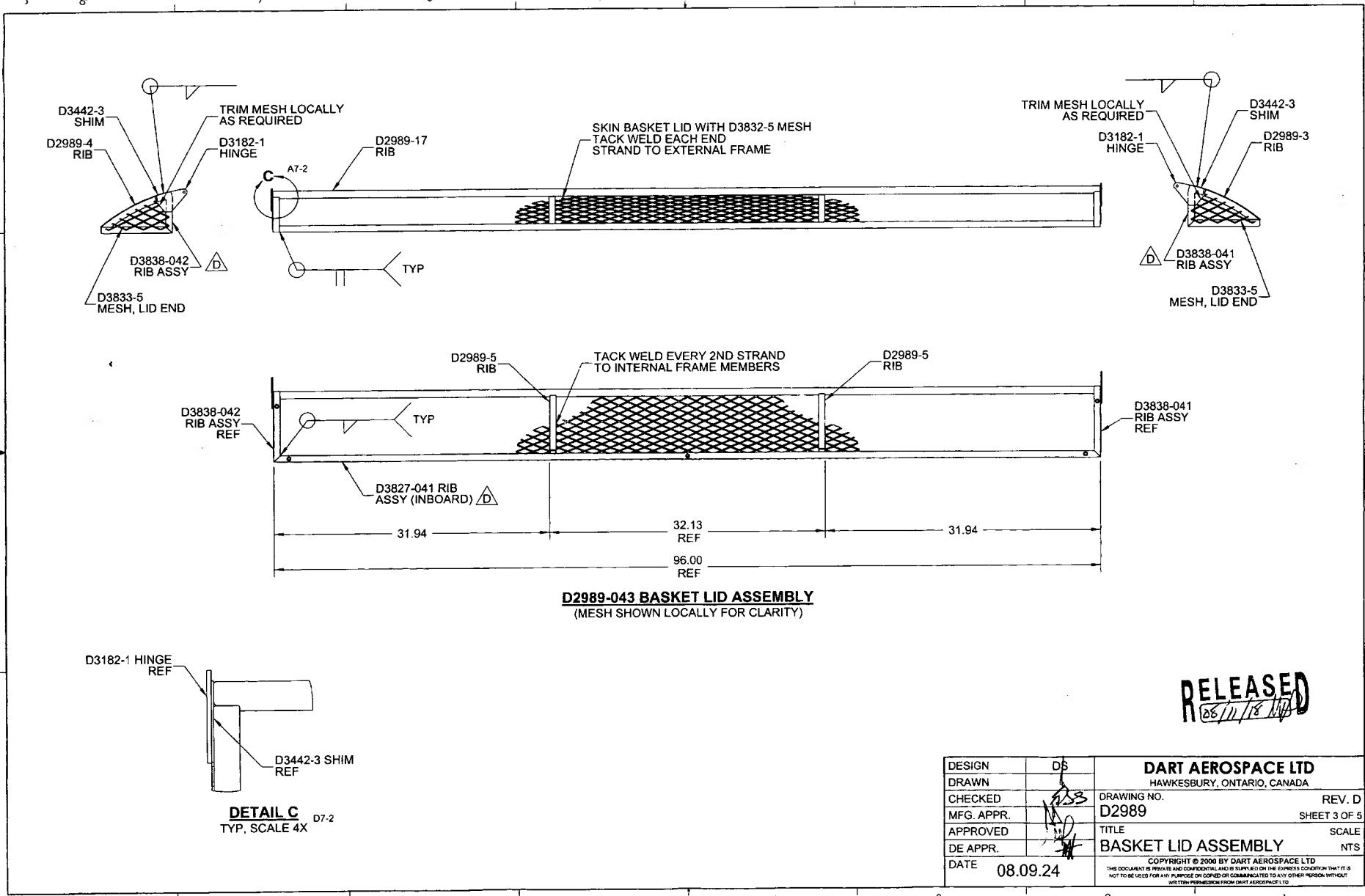
NOTES:

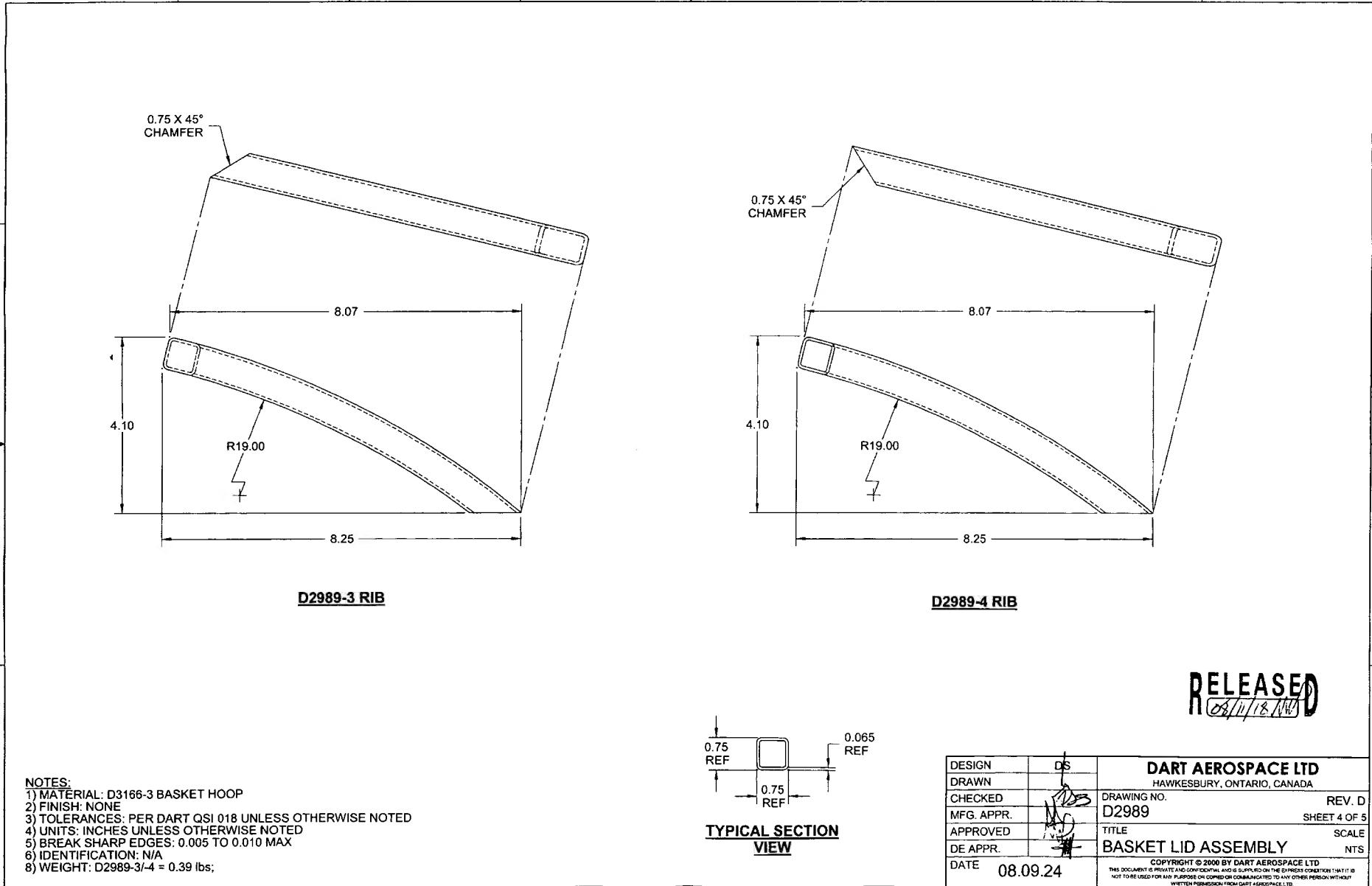
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

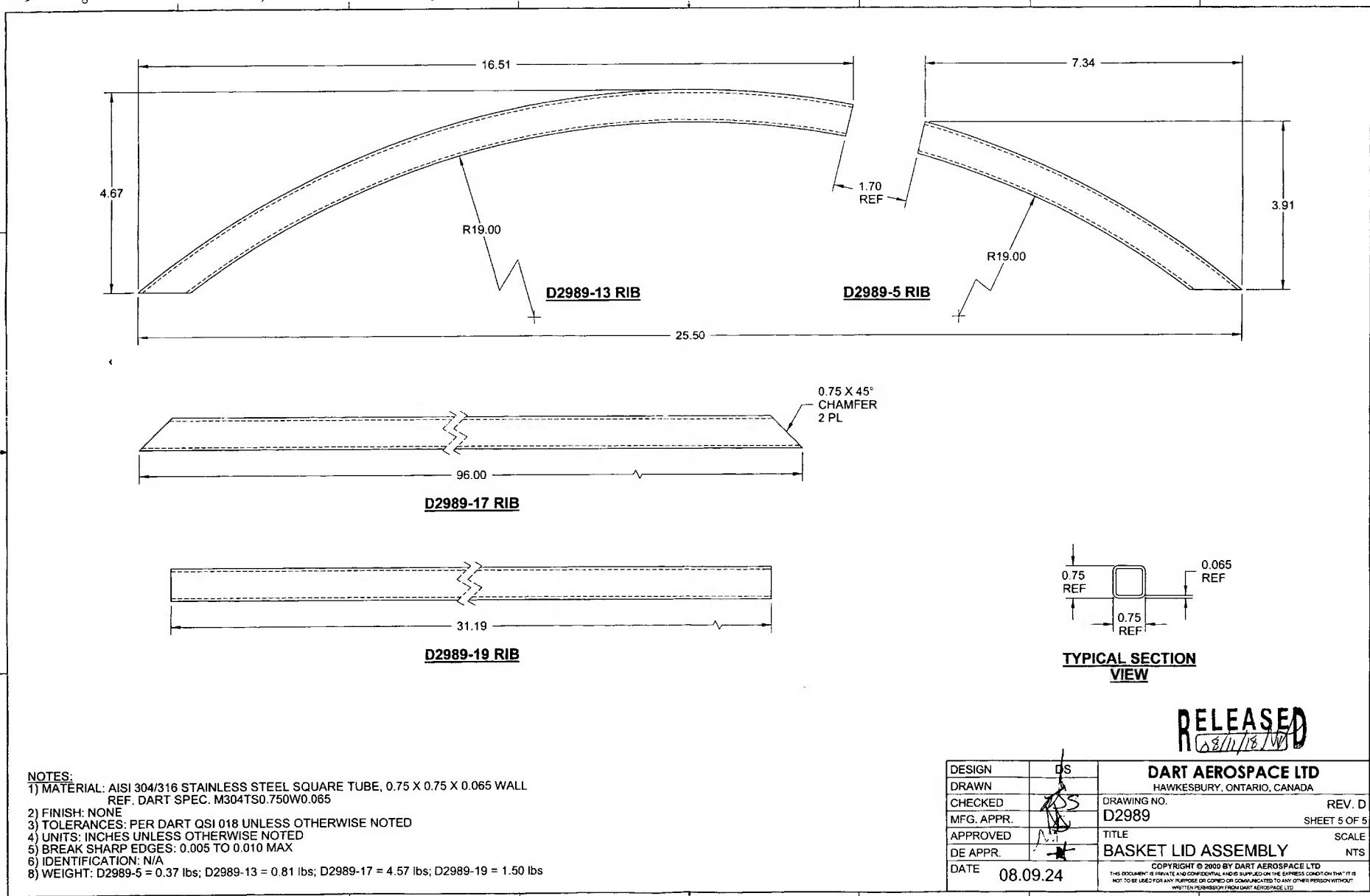
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-1/17. D3838-041 REPLACES D2989-1/19. D3838-042 REPLACES D2989-1/15. D3838-041 REPLACES D2989-1/17. D3838-042 REPLACES D2989-1/19. D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-9; REMOVED D327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/10 (NOW ON D3836 DWG), D2989-1/2-7/15 (NOW ON D3838 DWG) AND D2989-11/12 (NOW ON D3852 DWG). REASON TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	<i>RS</i>	D2989	SHEET 1 OF 5
MFG. APPR.	<i>RS</i>	TITLE	
APPROVED	<i>WV</i>	SCALE	
DE APPR.	<i>WV</i>	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	

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DESIGN	DS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. D
APPROVED		D2989
DE APPR.		SHEET 5 OF 5
DATE	08.09.24	TITLE
		SCALE
		BASKET LID ASSEMBLY
		NTS

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RELEASED
08/11/00